

# Work Order ID 75341

**\*75341\***

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October 21-11 7:58:13 AM

Item ID: D350-591-214

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Heli-Access-Step, Short RH

Stop **\*NS2\***

Start Date: 20/10/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 08/11/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/10/21 Tooling:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3078	A
DSI 9472	A

100 0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-214 CHG003

110

0.00

**\*110\***

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078  
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.  
3-Deburr

*Handwritten:* JG for MLJ 12-1-25 (4)

*Handwritten:* 12/01/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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 Item Name: Heli-Access-Step, Short RH  
 Start Date: 20/10/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 08/11/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00  0.00	Cpl	12.01.23		4x	0		
130 <b>*130*</b> Large Fab Large Fab	Large Fab  Memo 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078 A/RAluminum Rod 114514 3-Grind End Plate flush 119712	0.00  0.00	SJ	12.01.23		4x	0		
140 <b>*140*</b> QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				4	0		BE12-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 08/11/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
<b>*150*</b>									
QC	Memo	0.00				44			
Quality Control						44			
160	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*160*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

5 12/01/24

4 12-1-24

4 RH 4 12/01/24  
counted & measured

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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 Required Date: 08/11/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Large Fab	0.00							
<b>*200*</b>									
Large Fab	Memo	0.00							
Large Fab	1- Rivet Leg Assembly as per Dwg D3078.								
	2-Bevel Aft end for welding								
	3-Inspect for foreign object as per QSI 024								
	4-Weld Aft End Plate as per QSI 004 & Dwg D3078								
	A/R Aluminum Rod <u>114514</u>								
	5-Grind End Plate flush								
210	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									

*12.01.26*

*4*

*φ*

*512101127*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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 Required Date: 08/11/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC5- Inspect part completeness to step on W/O	0.00							
<b>*220*</b>									
QC	Memo	0.00							
Quality Control									
230	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*230*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*240*</b>									
Powdercoat	Memo	0.00							
Powder Coating									

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00  
3200F  
12:30

24  
RH

H BL 12-1-30.

4X Ø M-L 12/04/30

m u a 480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**\*N900040100\***

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Revision ID:

Item Name: Heli-Access-Step, Short RH

Stop **\*NS2\***

Start Date: 20/10/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 08/11/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC4- 100% Inspect kits for completeness	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									
290	Packaging	0.00							
<b>*290*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-214								
	Location: _____								
	PPP Rev: _____								
300	QC21- Final Inspection - Work Order Release	0.00							
<b>*300*</b>									
QC	Memo	0.00							
Quality Control									

8/12/02/03

QC  
RH

SPD 12-02-03

M.C.J. 12/02/06  
ME  
12-02-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75341

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Parent Item: D350-591-214

**\*D350-591-214\***

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 4.00

Required Qty: 4.00

**Comments:**

IPP Rev:B05.10.14Modified step 10KJ/EC

IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM

IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D

10.11.15 update qty on AN4-11A DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

110

Each

108.1200

0.5

2

**\*D2622-120C\***

Step Extrusion

\*\*

*Ac 12.01.20.*

Location

Loc Qty

Loc Code

HALL

98.42

64409

6

68293

0.5

72131

91.92

WA

9.7

46910

2

66970

7.7

*B75781 (X2)*

D3063-1

Manufactured No

130

Each

78.0000

1

4

**\*D3063-1\***

Support

\*\*

*12.01.23*

Location

Loc Qty

Loc Code

WA

78

66182

18

71886

60

*4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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Parent Item: D350-591-214

**\*D350-591-214\***

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3067-1 Manufactured No

130

Each

63.0000

1

4

**\*D3067-1\***

End Plate

\*\*

*12.01.23*

Location	Loc Qty	Loc Code
WA <u>B78022</u>	62	
67582	2	
73404	60	
WA016	1	
68214	1	

D3066-1 Manufactured No

200

Each

48.0000

2

8

**\*D3066-1\***

Spacer

\*\*

B77564 = 8

*12.01.26*

Location	Loc Qty	Loc Code
WA	48	
73409	48	

MS20600-AD4W4 Purchased No

200

Each

2,694.000

16

64

**\*MS20600-AD4W4\***

Rivets

\*\*

*12.01.26*

Location	Loc Qty	Loc Code
ST321 <u>B119883</u>	2689	
116188	59	
117364	253	
117601	200	
117885	195	
118840	1982	
WA018	5	
116712	5	

D3065-041 Manufactured No

200

Each

0.0000

1

4

**\*D3065-041\***

Step Leg Assembly Hi

\*\*

B 78797 = 4

*12.01.26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3067-1 Manufactured No

200

Each

63.0000

1

4

**\*D3067-1\***

End Plate

\*\*

*12.01.26*

Location

Loc Qty

Loc Code

WA B78022 62

67582 2

73404 60

WA016 1

68214 1

AN4-16A

Purchased No

270

Each

132.0000

4

16

**\*AN4-16A\***

Bolt

\*\*

Location

Loc Qty

Loc Code

ST358 132

117872 82

118838 50

D2732

Manufactured No

270

f

553.8700

1

4

**\*D2732\***

Rubber Extrusion

\*\*

*12/1/308 (4)*

Location

Loc Qty

Loc Code

ST 5

64283 5

ST410 548.87

70987 498.87

73759 50

Cut 3.00" long, qty 4

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Parent Item Name: Heli-Access-Step, Short RH

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 4.00

Required Qty: 4.00

AN3-35A Purchased No

270 Each 99.0000 2

**\*AN3-35A\***

Bolt

\*\*

M120187

Location

Loc Qty

Loc Code

ST353

99

117619

3

117794

1

118838

95

AN4-11A Purchased No

270 Each 264.0000 2

**\*AN4-11A\***

Bolt

\*\*

Location

Loc Qty

Loc Code

ST356

264

110382

1

115316

63

117872

100

118706

100

AN960JD416 NAS1149D0463J Purchased No

270 Each 0.0000 12

**\*AN960JD416\***

Washer

\*\*

M119058

D2230-3 Manufactured No

270 Each 183.0000 2

**\*D2230-3\***

Lug

\*\*

B77651 12/1/305/14

Location

Loc Qty

Loc Code

ST476

4

53881

4

ST480

179

70973

1

73396

178

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 4.00

Required Qty: 4.00

D2230-1 Manufactured No

270 Each 277.0000 2 8

**\*D2230-1\***

\*\*

B76640 y

Lug

## Location

## Loc Qty

## Loc Code

ST470	100
72811	100
ST476	177
67826	6
69821	11
70974	20
73398	140

MS21042L4 Purchased No

270 Each 13,961.00 6 24

**\*MS21042L 4\***

\*\*

Nut

## Location

## Loc Qty

## Loc Code

ST300	2961
117441	51
117601	537
118451	1373
118927	1000
ST516	6000
119017	6000
ST518	5000
119075	5000

AN960JD10 NAS1149D0363J Purchased No

270 Each 0.0000 4 16

**\*AN960JD10\***

\*\*

Washer

M120142 12/1/30 y

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER  
AND  
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER  
REF CANADIAN STC: SH92-6  
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

## ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

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NO. 75341 M.C.J.  
11/10/21

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: [Signature]  
D. SHEPHERD (DE # 02)  
DATE: 09.08.05  
CERT. NO.: SH92-6  
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>90</u>	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>LP</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>NCA</u>	DSI 9472	SHEET 1 OF 2
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	BOLT ADDITION	NTS
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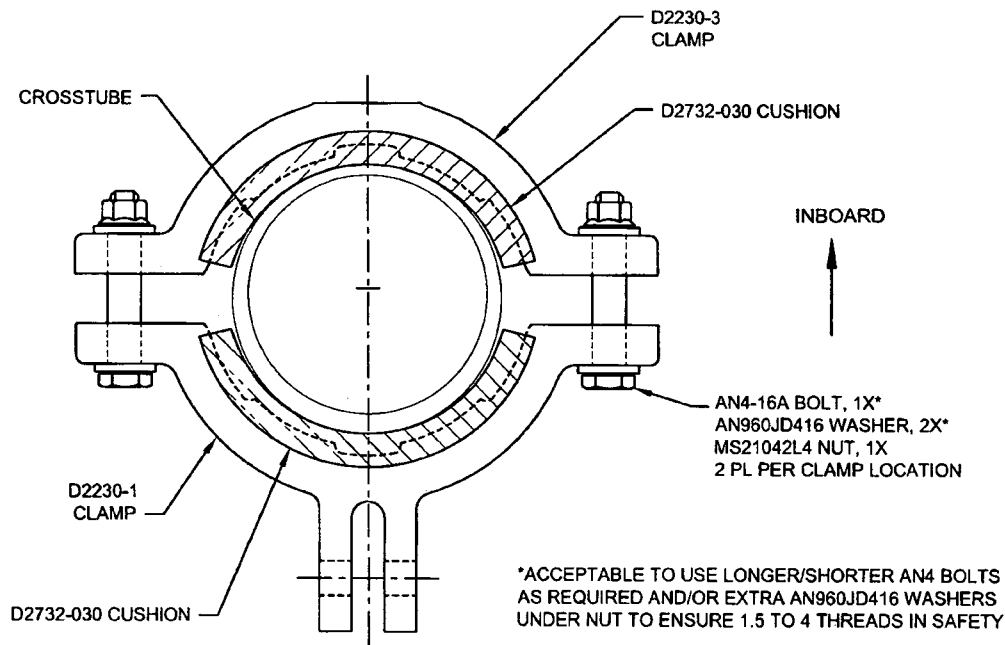
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**FIGURE 1: CLAMP DETAIL**  
**OPTIONAL CLAMP CONFIGURATION**

CANADA  
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AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
*[Signature]*

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.08.05  
CERT. NO.: SH92-6  
ISSUE NO.: 11

DESIGN	GP	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 2 OF 2
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75341

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3078</b>	REV. A SHEET 1 OF 2
DATE <b>02.09.11</b>		TITLE <b>STEP ASSEMBLY, HI SHORT</b> SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED  
02.09.20 *#*

SHC2001  
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NO. 75341 M.C.O.  
12/1/13

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

**GENERAL NOTES:**

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

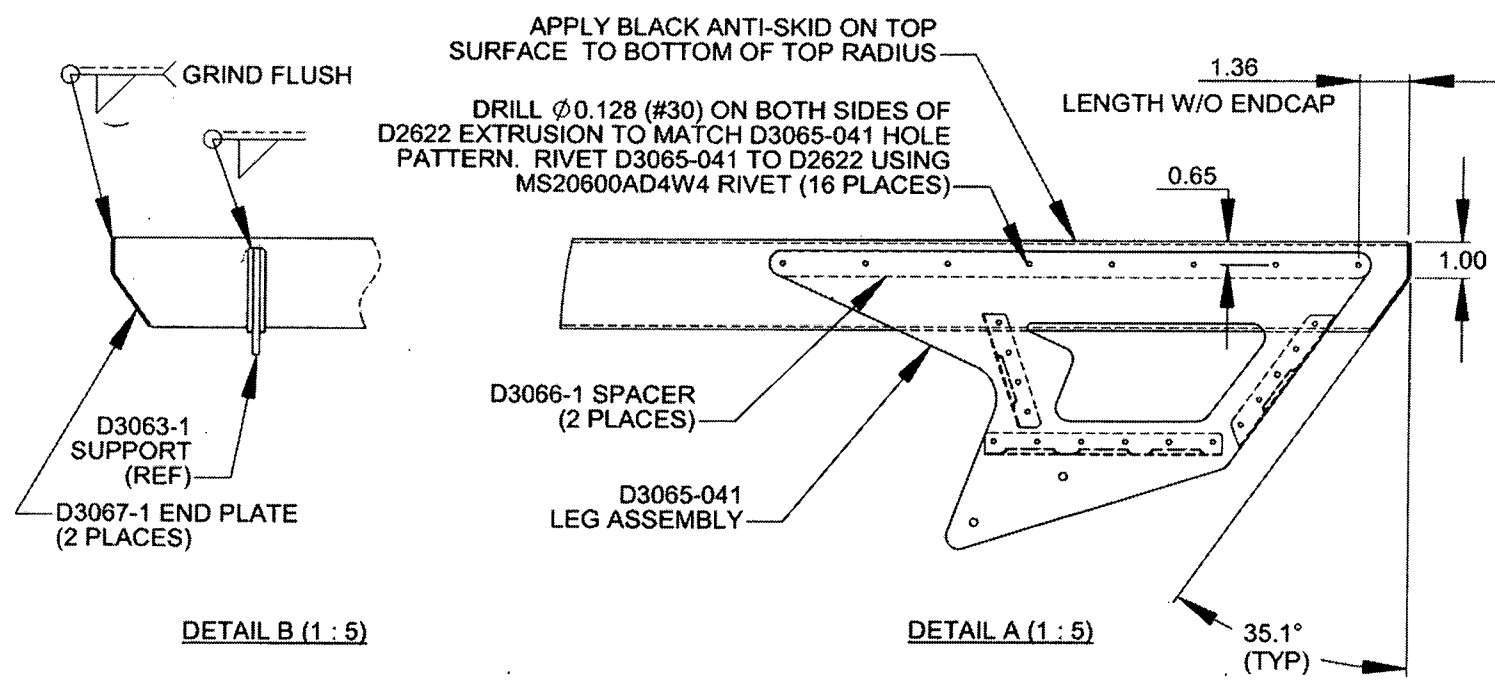
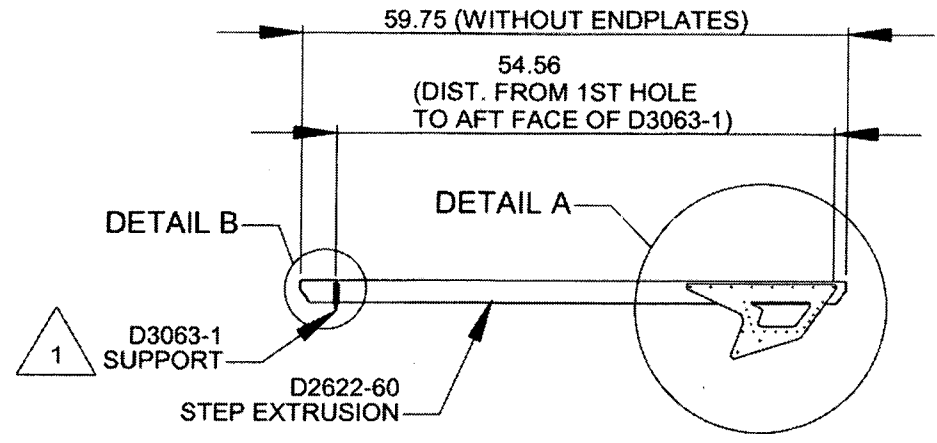


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02.09.2011

DESIGN	AP	DRAWN BY	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	APPROVED	AP	DRAWING NO. D3078
DATE	02.09.11	TITLE	STEP ASSEMBLY, HI SHORT	REV. A SHEET 2 OF 2
		SCALE	1:20	



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER  
AND  
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6  
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

**ADD:**





Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY:   
D. SHEPHERD (DE # 02)

DATE: 09.08.05  
CERT. NO.: SH92-6  
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. REV. A	
MFG. APPR.	N/A	DSI 9472 SHEET 1 OF 2	
APPROVED		TITLE SCALE	
DE APPR.		BOLT ADDITION NTS	
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